

# Work Order ID 70359

Friday, June 03, 2011 12:36:39 PM



Page 1

Item ID: D2221 Accept

Revision ID:

Item Name: 350 Basket Base

Start Date: 6/3/2011 Start Qty: 1.00

Required Date: 6/17/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: CL Date: 11/06/10 Tooling:

QC: Date: SPC (Y/N):



Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2221	Rev H
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100 0.00



Large Fab

Large Fab

Large Fab

## Memo

- 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
  - 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
  - 3- tack weld mesh on basket as per dwg D2221
- A/R ER316 S.S. Rod Batch: 115928

## \*\*\*PLEASE NOTE\*\*\*

IF MAKING -041A OR -043A :  
DRILL HOLES FOR GAS SPRING  
IN D3825-041 AS PER  
DSI 9473

Pl 11.06.10

SCAN PARTS → A.E 11.06.10

110 0.00



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

## Memo

BE 11/06/10  
11.06.10

1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

8 w/06/13

QC

Memo

0.00

Quality Control

125

Pressure Wash per QS1005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

IX  $\phi$  m/f 11/06/13

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Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/ Work Center ID Operation Description Set Up/ Run Hours

130 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00



Powdercoat

Powder Coating

Memo

1- Plug holes prior to

1ST COAT:

START TIME: 1:30

OVEN TEMPERATURE: 400 OF

FINISH TIME: 2:00

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

140 QC3- Inspect Part Finish 0.00



QC

Quality Control

Memo

0.00

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

H ~~Ø~~ M-11/06/13

1 ~~BF~~ 11-6-14

M116964

W/O:		WORK ORDER CHANGES						
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Page 4

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Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

*W/O*

0.00

Packaging

*70331*

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*ES 11/06/14 @**11/6/14**MF 11-06-14*

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# Picklist Print

Friday, June 03, 2011 12:36:35 PM

Page 1

Work Order ID: 70359

Parent Item: D2221

Parent Item Name: 350 Basket Base



Start Date: 6/3/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	18.0000	1	1			
<u>Location</u>						<u>Loc Qty</u>		<u>Loc Code</u>					
WA						8							
69261						8							
WA006						10							
67465						10							
D2221-5  Rib		Manufactured	No			100	Each	14.0000	2	2			
<u>Location</u>						<u>Loc Qty</u>		<u>Loc Code</u>					
WA006						14							
67117						2							
67399						4							
69257						8							
D2221-7  Rib		Manufactured	No			100	Each	7.0000	1	1			
<u>Location</u>						<u>Loc Qty</u>		<u>Loc Code</u>					
WA						4							
70130						4							
WA006						3							
67274						3							

PL 11.06.10

PL 11.06.10

PL 11.06.10

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Friday, June 03, 2011 12:36:35 PM

Page 2

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Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 6/3/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100

Each

14.0000

2

2



Basket Hinge

Location

WA005

69211

Loc Qty

14

14

Loc Code



Pl 11.06.10

D2235-1

Manufactured No

100

Each

18.0000

2

2



Basket Rib

Location

WA

68606

69651

WA005

66895

Loc Qty

14

4

10

4

4

Loc Code



Pl 11.06.10

D2581

Manufactured No

100

Each

84.0000

2

2



Mounting Bracket

Location

WA

68964

69258

69739

Loc Qty

84

16

28

40

Loc Code



Pl 11.06.10

D3442-1

Manufactured No

100

Each

9.0000

2

2



Shim

Location

WA005

64271

65783

Loc Qty

9

2

7

Loc Code



Pl 11.06.10

Friday, June 03, 2011 12:36:36 PM

Shop Packet Print

Page 2

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Page 3

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Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 6/3/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100

Each

4.0000

2

2



Rib Assembly (Basket End)

Location

WA

69984

Loc Qty

4

4

Loc Code

100

Each

4.0000

2

②

D3826-041

Manufactured No



Rib / Gusset Assembly

Location

WA

67464

Loc Qty

4

4

Loc Code

100

Each

7.0000

1

②

D3827-041

Manufactured No



Rib Assembly (Inboard)

Location

WA

69114

WA006

67275

Loc Qty

6

6

1

1

Loc Code

100

Each

4.0000

1

①

D3832-1

Manufactured No



Mesh (Base)

Location

WA

67477

69173

Loc Qty

4

1

3

Loc Code

①

Friday, June 03, 2011 12:36:37 PM

Shop Packet Print

Page 3

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Page 4

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Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 6/3/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

11.0000

2

2



Mesh (Base End Face)



*PL 11-06-10*

Location

Loc Qty

Loc Code

WA

11

65937

2

67459

9

(2)

Friday, June 03, 2011 12:36:37 PM

Shop Packet Print

Page 4

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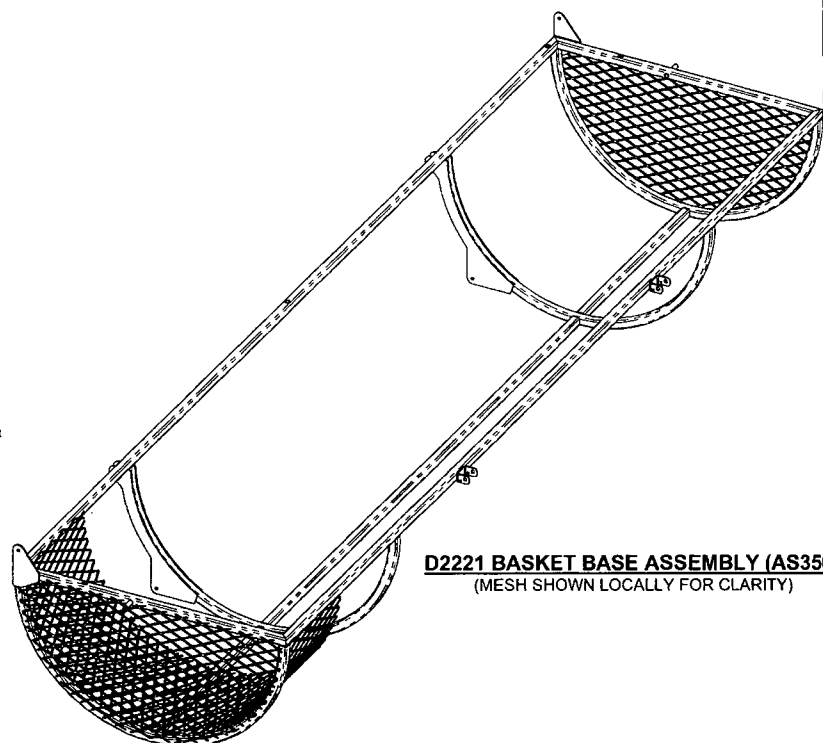
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**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 42.00 lbs APPROX
- 8) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

C211106/03

WID: 70359

**RELEASED**  
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	ASS	D2221	SHEET 1 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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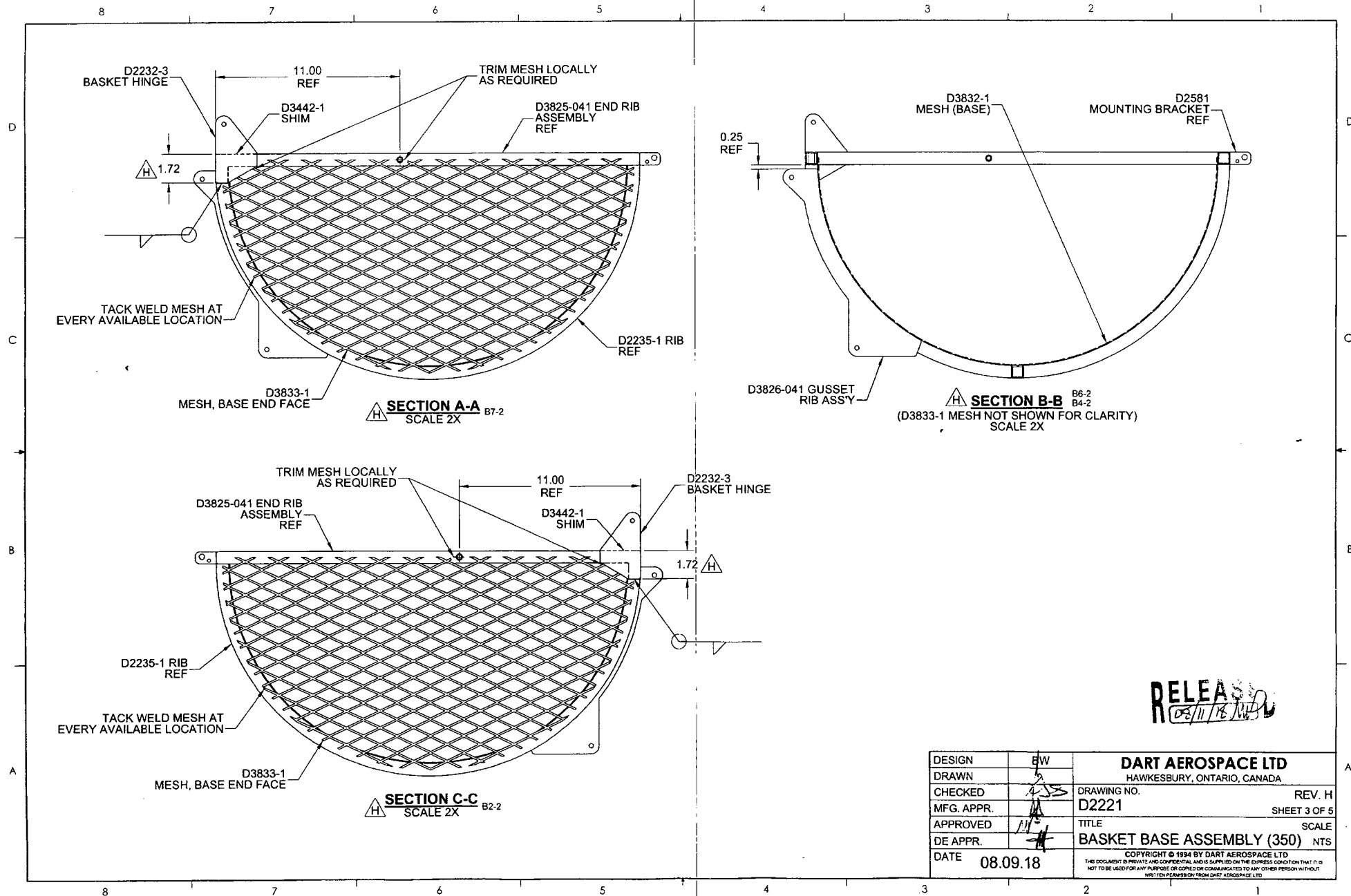
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RELEASED  
03/11/18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	123	DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 3 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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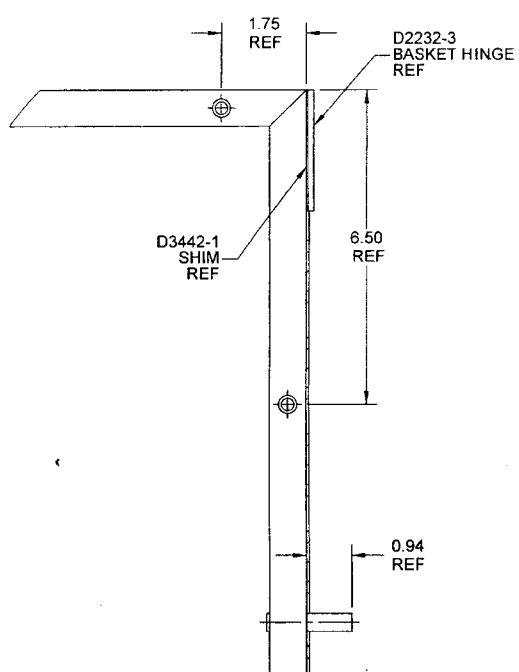
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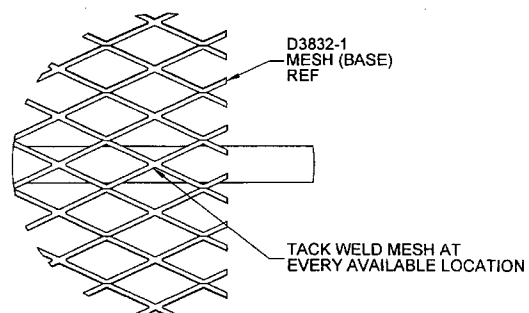
8 7 6 5 4 3 2 1

D  
C  
B  
A

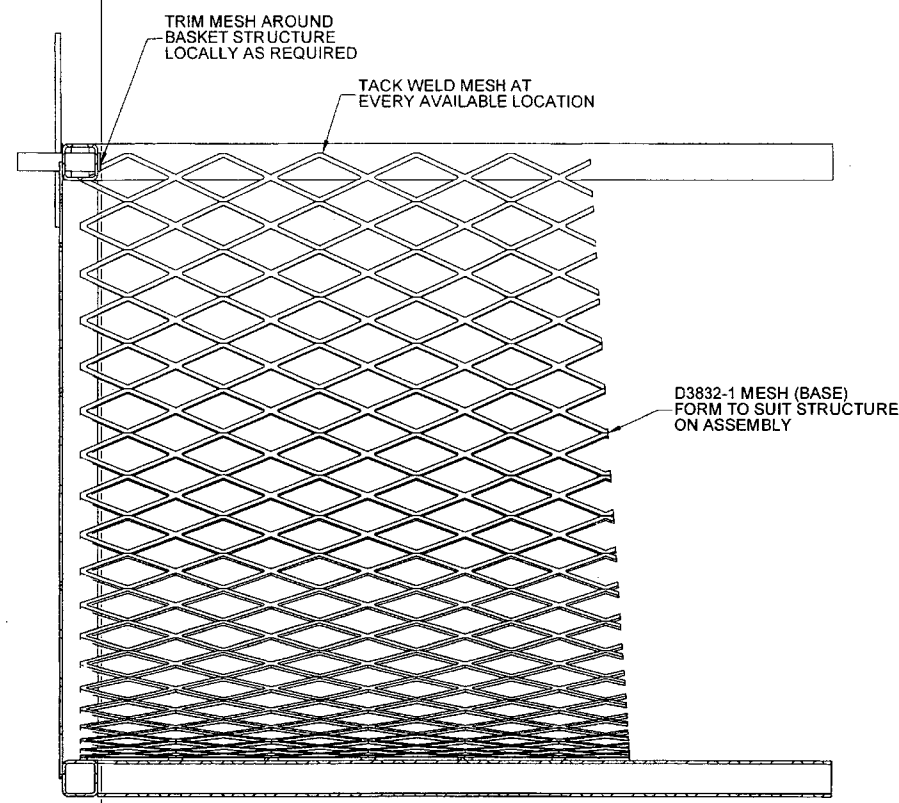
D  
C  
B  
A



**DETAIL D**  
SCALE 4X D2-2



**DETAIL E**  
SCALE 4X C6-2



**SECTION F-F**  
SCALE 4X D7-2

**RELEASED**  
02/11/18

DESIGN	BV	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	16/3	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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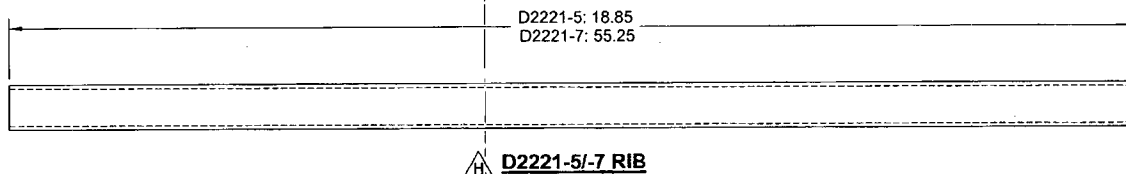
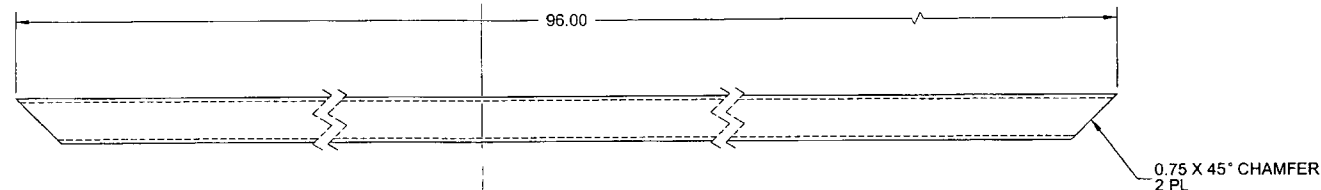
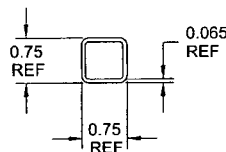
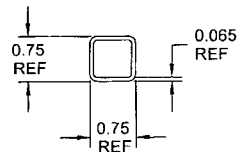
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

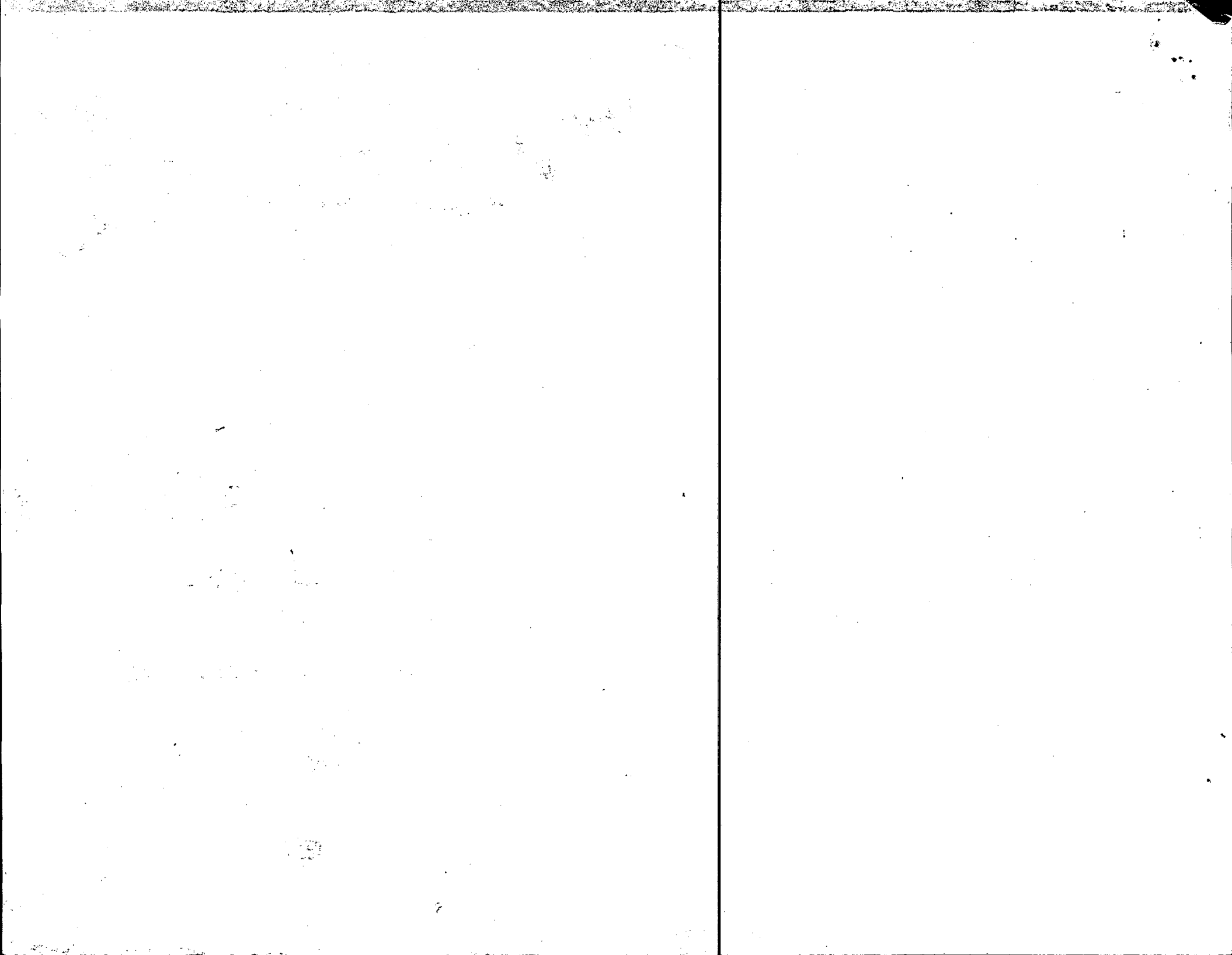


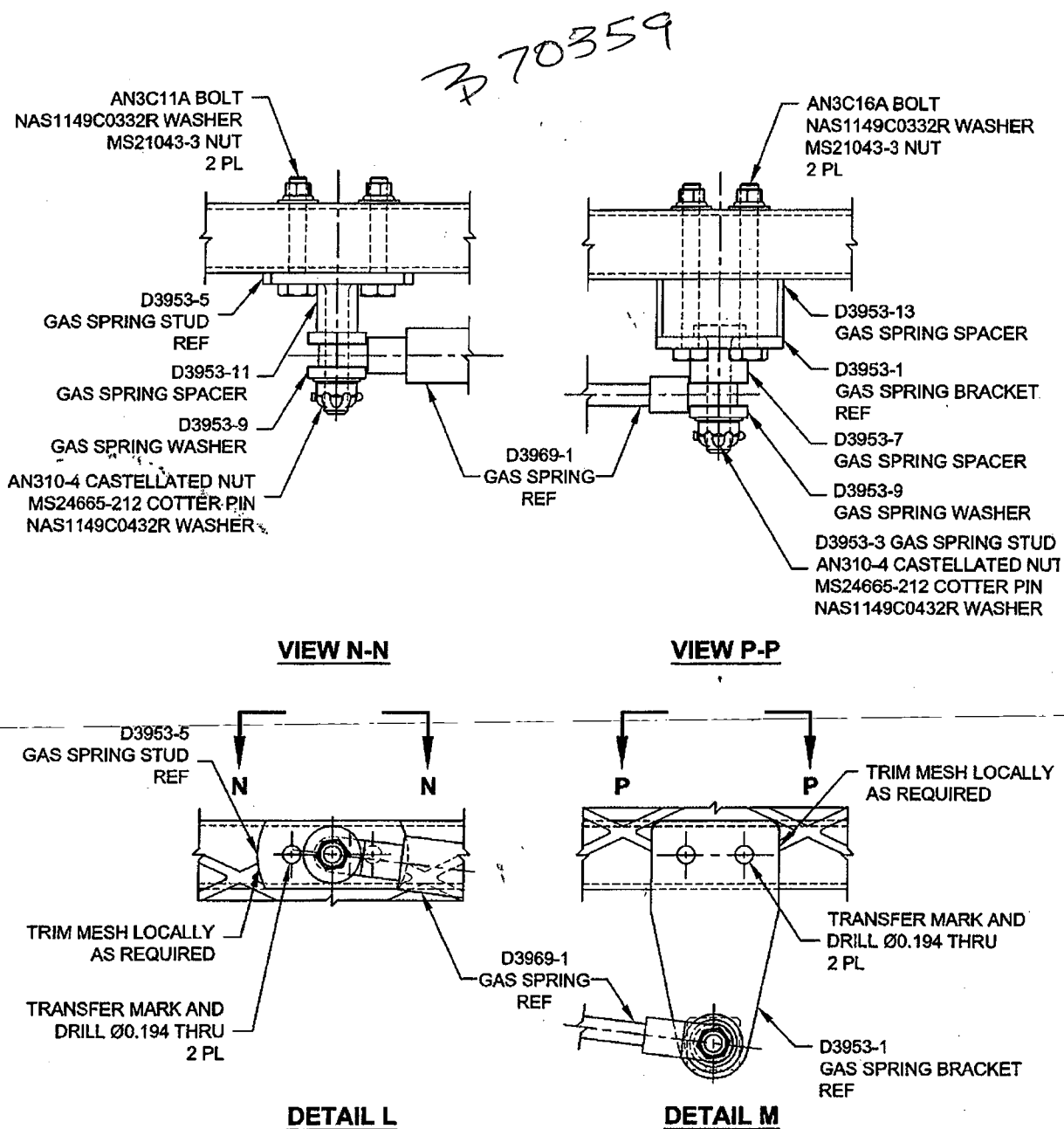


- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
08/11/18



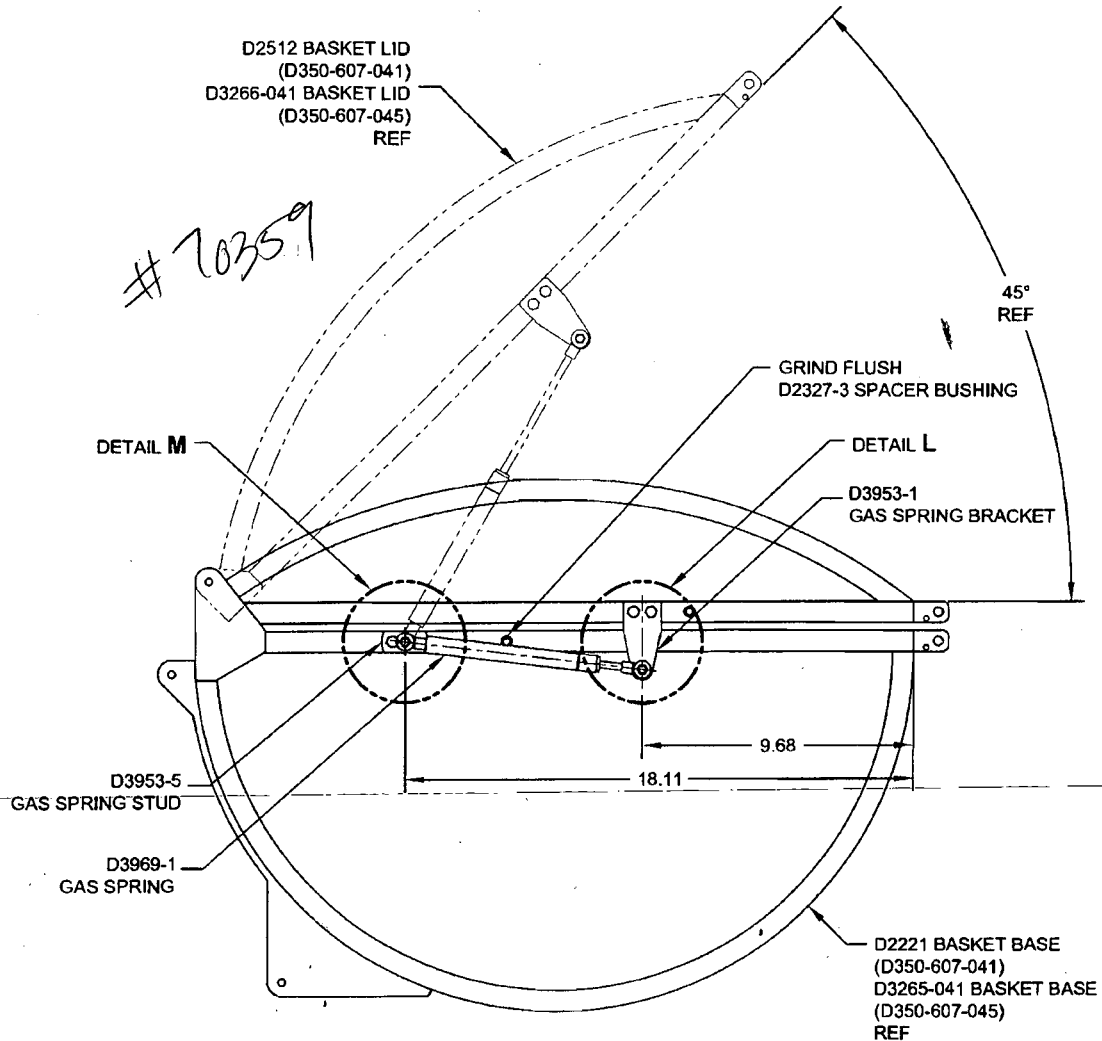


**Figure 8b – Automatic Lid Opener Installation**

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Revision: **A**

Date: 10.03.10



**D350-607-141 AUTOMATIC LID OPENER INSTALLATION**  
(BOTH ENDS)

**D350-607-145 AUTOMATIC LID OPENER INSTALLATION**  
(1 END ONLY)

**FIGURE 25-7A - AUTOMATIC LID OPENER INSTALLATION**

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**25-00-00**